



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4975-1
Job Sheet 184209



Part No: D4975-1

Job Qty: 4 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 14.06.13 AS PER DWG REV.A DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	4 pcs		11/2/18	0.00	0.40	Waterjet 1		SL 18/10/18 DAS
120	QC	4 pcs		11/2/18	0.00	0.00	QC8		OCT 10 2018 68
130	Brake NC	4 pcs		11/2/18	0.06	0.16	Brake NC 2		SB DAS 9-89
140	QC	4 pcs		11/2/18	0.00	0.00	QC6		38
150	HandFinish	4 pcs		11/2/18	0.00	0.14	HandFinish1		BE3 18-10-22
160	QC	4 pcs		11/2/18	0.00	0.00	QC7-4		38
170	Packaging	4 pcs		11/2/18	0.00	0.00	Packaging3-2	6x132	9-89
180	QC21-SA	4 Ea		11/2/18	0.00	0.00	QC21		21 NOV 15 2018 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.1000 sf (.025 ea)	100-Waterjet	5076996

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M6061T6S.063	0	206	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.250Inches ± 0.030	0.280 0.220	0,251	
2	Bracket	0.250Inches ± 0.030	0.280 0.220	0,250	
3	Bracket	0.680Inches ± 0.030	0.710 0.650	0,683	
4	Bracket	0.690Inches ± 0.030	0.720 0.660	0,689	
5	Bracket	0.617Inches ± 0.010	0.627 0.607	0,615	
6	Bracket	0.878Inches ± 0.010	0.888 0.868	0,876	
7	Bracket	1.380Inches ± 0.030	1.410	1,376	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																					
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____																																																																																					
Description Work Order Deviation Completed By _____ / Supervisor Verification Coordinator Approval L.J. Russell, Project Manager Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S116825 Part: D4975-1 Job No: 184209 Serial No/Batch: S116825 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/09/18																																																																																									
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			1.350		
8	Bracket	2.590Inches $\pm$ 0.030	2.620 2.560	2,591	
9	Bracket	0.098Inches + 0.004 - 0.001	0.102 0.097	0,098	Diameter
10	Bracket	0.768Inches + 0.010 - 0.001	0.778 0.767	0,768	Diameter

Plex 10/3/18 2:02 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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